








Work Order ID 70076




Thursday, May 26, 2011 11:26:02 AM



Page 1

Item ID: D3909-041 Accept  Setup Start 
Revision ID:
Item Name: Crosstube Lug Assembly, Fwd ³ Stop 
Start Date: 5/26/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 6/3/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: *P* Date: 7-05-26 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3909	C								
100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									
110		0.00							
									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg Trim rivet to 1.185" long								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

EF 5/26/05/26 (3)

EF 5/26/05/26 (3)

5/27/05

(3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70076

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Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>SLO</u> Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/5/27 (3/1) \$

11/5/30

ME

11-05-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Thursday, May 26, 2011 11:26:08 AM

Page 1
4[illegible]

Required Date: 6/3/2011

Required Qty: 4.00

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	17.0000	1	4		EP 11/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				17					
					66873			17					
D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	7.0000	2	8		EP 11/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				7					
					65627			7					
D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	16.0000	1	4		EP 11/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST081				16					
					57819			1					
					65628			15					
D3909-5  Eyebolt Stud		Manufactured	No			100	Each	12.0000	1	4		EP 11/05/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				12					
					65629			12					

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 70076

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

D3910-1 Manufactured No 100 Each 20.0000 2



Crosstube Lug

Location

Loc Qty

Loc Code

st507

20

68867

20

D3917-1 Manufactured No 100 Each 13.0000 2



Washer

Location

Loc Qty

Loc Code

ST092

13

66322

13

AN3C12A Purchased No 100 Each 84.0000 4



Bolts

Location

Loc Qty

Loc Code

ST351

84

116924

6

117514

48

117794

30

AN3C13 Purchased No 100 Each 52.0000 1



Bolt

Location

Loc Qty

Loc Code

ST351

52

114304

2

114714

50

8
5/26/26
B6 8263 (20)
4
8
5/26/26
6
16
5/26/26
12
4
5/26/26
2
1

Thursday, May 26, 2011 11:26:08 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Work Order ID: 70076

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

MS17984-C413

Purchased

No

100

Each

30.0000

1

4



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

30

114340

2

117343

8

117557

20

MS20615-41120

Purchased

No

100

Each

180.0000

3

12



RIVET

Location

Loc Qty

Loc Code

GA

180

117071

180

AN310C3

Purchased

No

100

Each

50.0000

1

4



Castellated Nut

Location

Loc Qty

Loc Code

ST349

50

114714

50

MS21043-3

Purchased

No

100

Each

596.0000

4

16



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

516

112314

516

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Page 3

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Page 4

Work Order ID: 70076

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

MS24665-151

Purchased

No

100

Each

483.0000

1

4



Cotter Pin

Location

Loc Qty

Loc Code

ST309

483

17566

483

NAS1149C0332R

Purchased

No

100

Each

2,492.000

8

32



Washer

Location

Loc Qty

Loc Code

ST297

2492

116304

55

117291

1837

117460

600

NAS1149C0363R

Purchased

No

100

Each

4,492.000

2

8



Washer

Location

Loc Qty

Loc Code

ST297

4492

114742

4492

Thursday, May 26, 2011 11:26:09 AM

Shop Packet Print

Page 4

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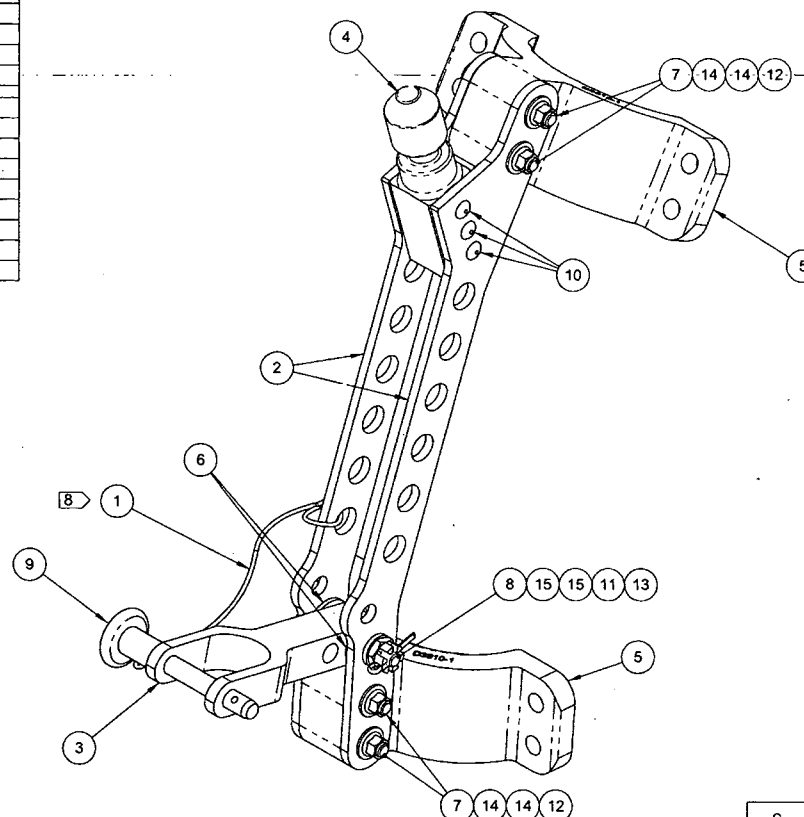
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70074

PL 05-24

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041/-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED, SECTION A-A & DIM Ø0.650 REMOVED, SIDE VIEW ADDED, DIM 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05, WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D3910-1
X-TUBE LUG
2 PL

D2690-6
LANYARD

MS17984-C413
PIP PIN

D3917-1
WASHER

D3909-5
EYEBOLT STUD

MS20615-4M20
RIVET
3 PL

D3909-1
FWD X-TUBE LUG PLATE
2 PL

D3909-3
FWD LOWER ATTACH ARM

AN3C12A BOLT
NAS1149C0332R WASHER, 2X
MS21043-3 NUT
4 PL

AN3C13 BOLT
NAS1149C0363R WASHER, 2X
AN310C3 NUT - CASTELLATED
MS24665-151 COTTER PIN

D3909-041 FWD X-TUBE LUG ASSY

cto 70076

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. C
CHECKED	<i>[Signature]</i>	D3909	SHEET 2 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.18		

Dart Aerospace Ltd

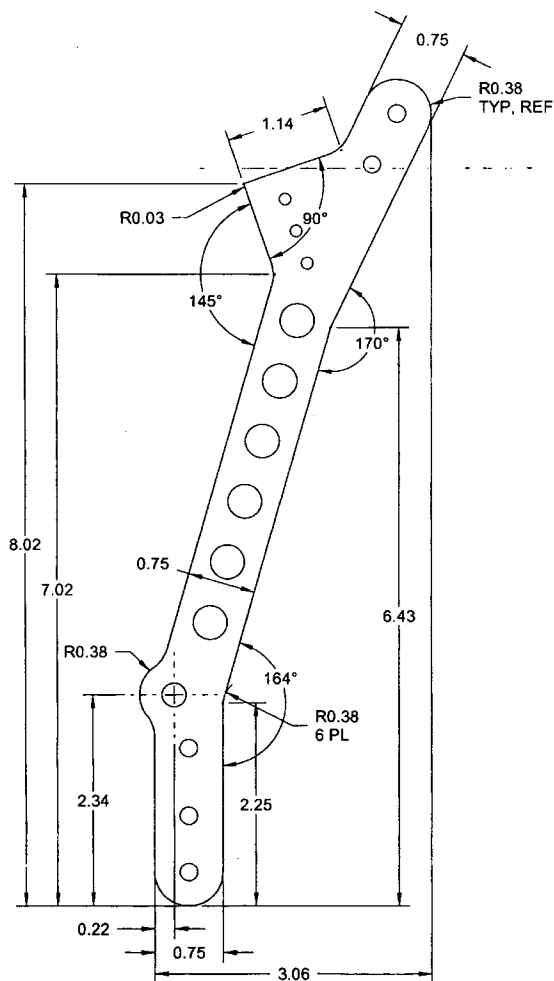
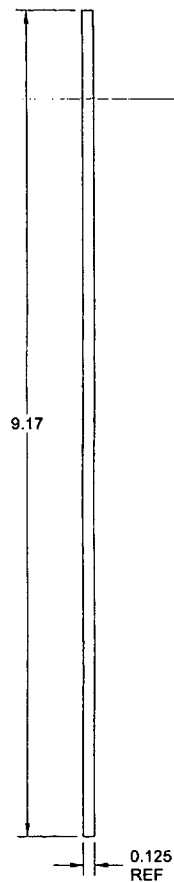
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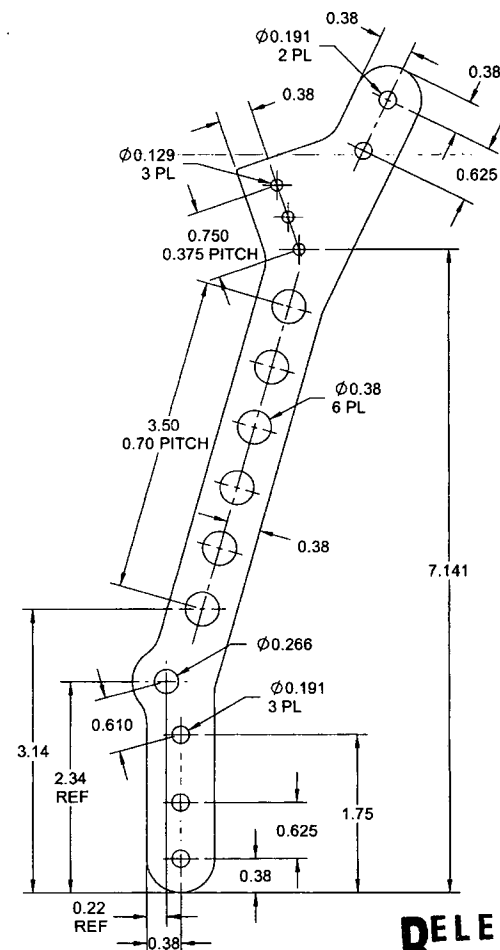
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D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

RELEASED
2010-08-01

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-6059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3909	SHEET 3 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		FWD X-TUBE LUG ASSY.	NTS
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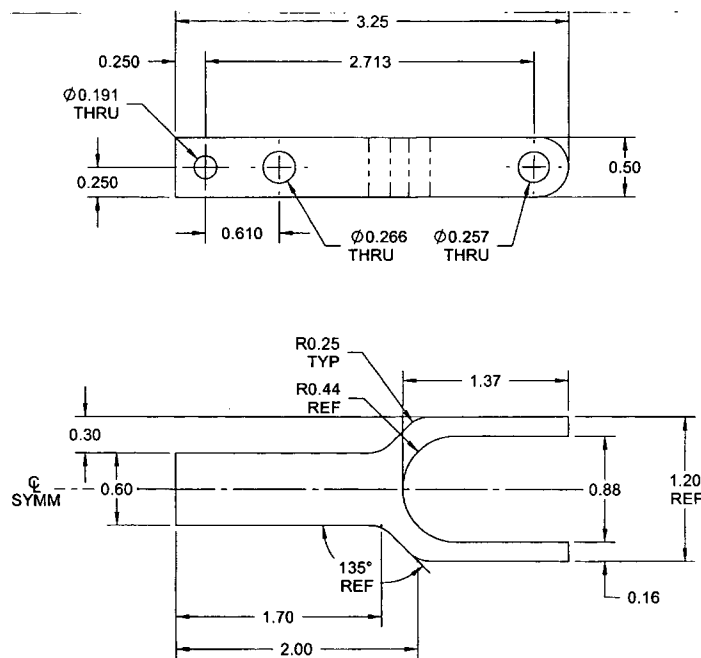
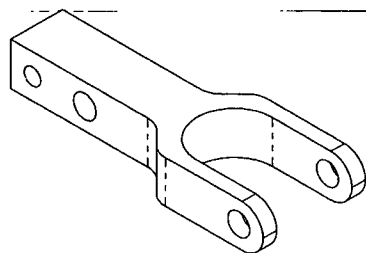
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D3909-3 FWD LOWER ATTACH ARM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
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w/10 70076

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2010-08-06
WV

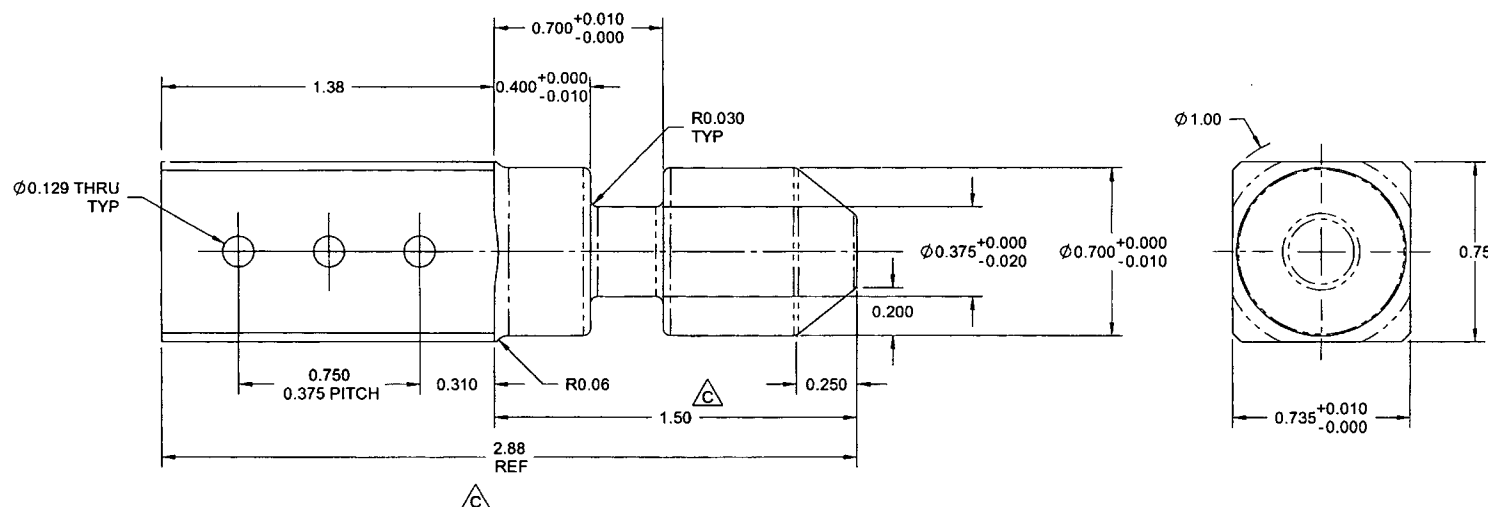
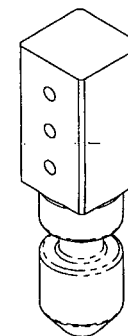
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D3909-5 EYEBOLT STUD

RELEASED
2010-08-04

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 5 OF 5
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